

Date: Thursday, 15/01/2009 11:15:08 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 44816		
Estimate Number	: 12840		
P.O. Number	:	Part Number	: D35421
This Issue	: 15/01/2009 S.O. No. :	Drawing Number	: D3542 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 38296	Material	:
Written By	:	Due Date	: 10/02/2009 Qty: 12 Um: Each
Checked & Approved By	: <u>JUL 09.01.15</u>		
Comment	: Est Rev: A New Issue 07-04-23 JLM		
	: Est Rev: B updated powder coat per NCR 07.05.16 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B3000X01500	6061-T6 Bar 3.00 x 1.50
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Comment: Qty.: 0.3500 f(s)/Unit Total : 4.1996 f(s)

6061-T6 Bar 3" x 1.5"

BATCH: M109058 JF/DJP 09/01/18

2.0	BAND SAW	BAND SAW
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(12)



Comment: BAND SAW

Cut blank 4.0" long

J.F. / DJP 09/01/18

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA684 Rev: AA & Dwg D3542 Rev: A

2-Deburr per dwg D3443

J.F. / DJP 09/01/19

(14)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. / DJP 09/01/19

(14)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S.F. 09/01/21 (14)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3542-1 PAR #: N/A Fault Category: MACHINE NCR: Yes No DQA: A Date: 09.01.28
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: DD Date: 09/02/02

NCR: <u>44816</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/01/19	3-D	one part scrap. hole is drill out to 0.316" should be 0.266 ^{+0.000} _{-0.005} R.C. operator used wrong center drill hammer operator screw up	PA 09.01.19 QSI 042	φ0.266 hole is structural see attached IJN-D412-702 PS 20 Rev E SCRAP and Destroy Q14 (X) B# 109058	PA 09.01.19 QSI 042 DJP	S 09/01/19	PA 09.01.19 QSI 042	S 09/01/19
09.01.20	3	Qty 2 DIMENSION 0.500 FOR φ0.266 HOLE IS ACTUALLY 0.512 and 0.478 RC operator error.	PA 09.01.19 QSI 042	PART WAS TEST FIT PER IJN-D412-702 PS 20 REV E and found to fit OKAY - PARTS IS ACCEPTABLE ALL	JF. 09/01/25	S 09/01/20	PA 09.01.19 QSI 042	S 09/01/20

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 44816

Part Number: D35421

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING-RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 09.01.21 (14)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*****ENSURE TO MASK INSIDE BORE*****

START TIME:

9:30am

OVEN TEMPERATURE:

320°F

FINISH TIME:

8:00am

sl

09.01.23

RU

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F2 09/01/23

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST243A

JS

09/01/23 RU

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/26

Job Completion



MF 09-01-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

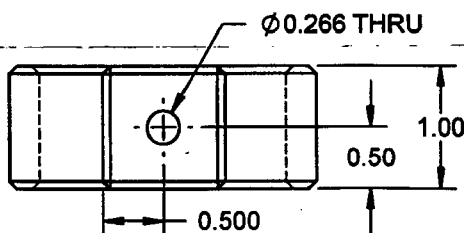
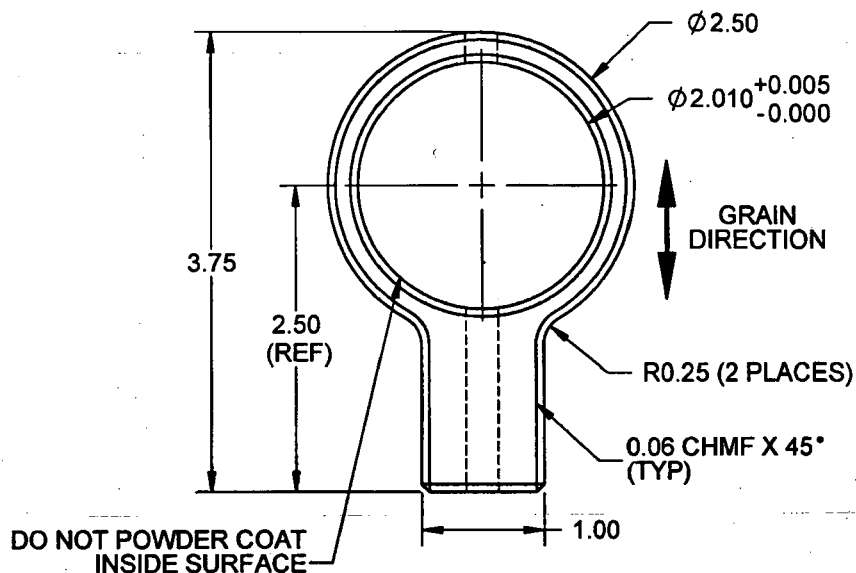
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



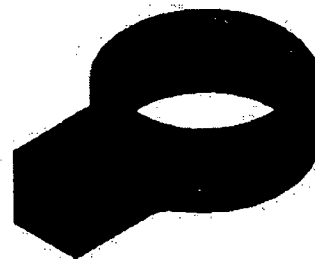
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3542	REV. A SHEET 1 OF 1
DATE 06.11.27	TITLE BRACKET		SCALE 2:3
REV A	DATE 06.11.27	DESCRIPTION NEW ISSUE	

RELEASED
07.04.02



D3542-1 BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *H4816*

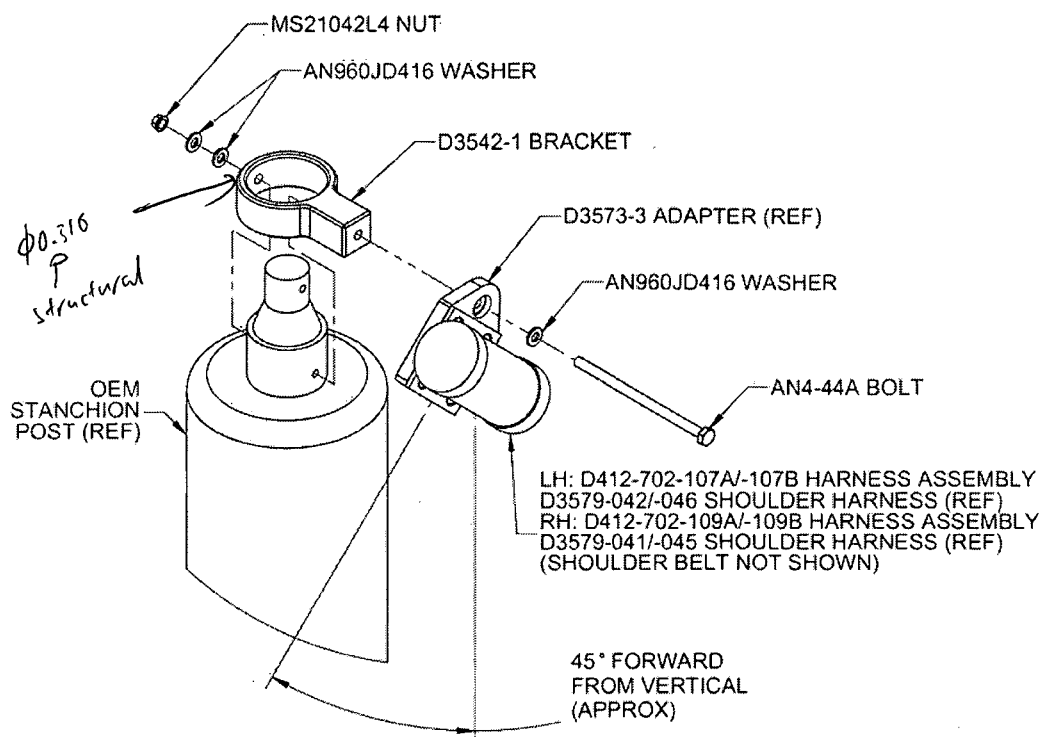


NOTES:

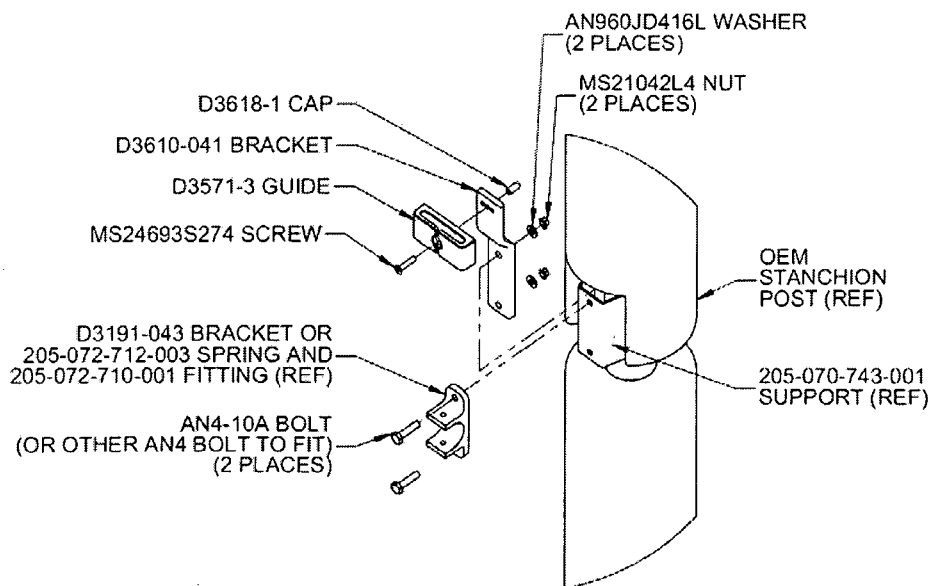
- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3 EXCEPT WHERE NOTED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3542-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DETAIL 'D' SHOULDER HARNESS INSTALLATION ON STANCHION POST
(LH POST SHOWN; RH POST OPPOSITE) --



DETAIL 'E' GUIDE INSTALLATION ON STANCHION POST
(LH POST SHOWN; RH POST OPPOSITE)